

Work Order ID 50911

July 24, 2009 4:08:48 PM



Item ID: D3874-2
Revision ID: A
Item Name: Floor Protector

Accept



Setup Start



Stop



Start Date: 07/27/2009 Start Qty: 6.00

Required Date: 08/31/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

28.5x44

M111588 BB
09/07/28 X6

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9453
Dwg Rev: A
Folio Rev: A

BB
09/07/28 X6
X1

Scrap

P10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3874-2 PAR #: N/A Fault Category: ALARM NCR: (Yes) No DQA: 18 Date: 09.08.12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 18 Date: 05.08.17

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|------------------------------|--|------------------------------|------------------------------|------------------------------|------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09/07/28 | 110 | PART NOT CORRECTLY FORMED R.C. program temp (shop) | <u>BB</u> <u>09/07/28</u> | SEAL MOLD INCREASE TEMP. 325-334° - Replace Qty 1 | <u>BB</u> <u>09/07/28</u> | <u>18</u> <u>09.08.06</u> | <u>BB</u> <u>09.08.06</u> | <u>18</u> <u>09.08.06</u> |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 50911

July 24, 2009 4:08:48 PM



Page 2

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Setup Start



Stop



Start Date: 07/27/2009 Start Qty: 6.00



Required Date: 08/31/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

Visually inspect part for proper formation and texture

BB 09/08/05 X6

130

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

=) 08/08/05 X6

140

HandThermo

0.00



HandThermo

Hand Finishing Thermoforming

Memo

0.00

I-Trim to finished dimensions as per Dwg

BB 09/08/06 X6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 50911

July 24, 2009 4:08:48 PM



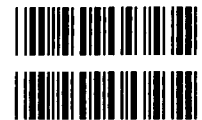
Page 3

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Revision ID: A
Item Name: Floor Protector

Accept



Setup Start
Stop



Start Date: 07/27/2009 Start Qty: 6.00
Required Date: 08/31/2009 Req'd Qty: 6.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo
Complete FAI document

0.00
0.00

BB

09/08/06

X6

P125 →

160

QC
Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00
0.00

⇒ 8 09/08/07

X5

φ

170

Packaging
Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00
0.00

9/8/17

SV SP

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3874-2 PAR #: NA Fault Category: Thermo NCR: Yes No DQA: 10 Date: 09-08-12
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 7 Date: 09-08-17

| NCR: <u>50511</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------------|--|---------------------------------------|---|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| <u>7/8/17</u> | <u>140</u> | <u>Part Found with 10 Large scratches in the Plastic</u> | <u>[Signature]</u> <u>09/08/17</u> | <u>Scrap and Destroy</u> <u>no replace</u> | <u>[Signature]</u> <u>09/08/17</u> | <u>[Signature]</u> <u>09/08/17</u> | <u>[Signature]</u> <u>09/08/17</u> | <u>[Signature]</u> <u>09/08/17</u> |
| | | <u>R.C Operator lost control of the saw. L.O.A.</u> | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 50911

July 24, 2009 4:08:48 PM



Page 4

Item ID: D3874-2
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Item Name: Floor Protector

Accept



Setup Start



Stop



Start Date: 07/27/2009 Start Qty: 6.00



Required Date: 08/31/2009 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date:

Tooling: Date:

QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
09-08-08
05-08-12

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

July 24, 2009 4:08:48 PM

Work Order ID: 50911

Parent Item: D3874-2RevA

Parent Item Name: Floor Protector

Comments:

Start Date: 07/27/2009

Required Date: 08/31/2009

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MLEXS.118-90318-08 | | Purchased | No | | | 100 | sf | 600.0000 | 26.2800 | | | |



Lexan Sheet

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 600 | |
| 111588 | 600 | |

M 111 588 BB 09/08/06 (X6) +1

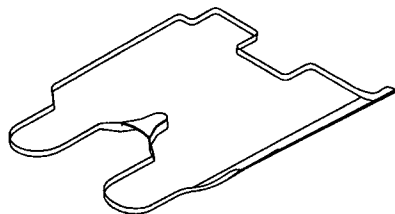
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

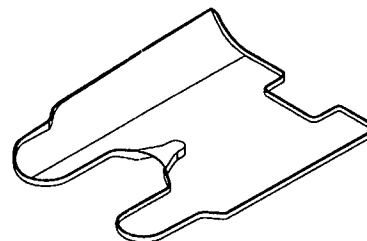
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

#50911

RELEASED
29/05/10

| | | | |
|------------|-------------|--|--------------|
| A | NEW ISSUE | PH | 09.01.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PH | | |
| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3874 | SHEET 1 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | FLOOR PROTECTOR | NTS |
| DATE | 09.01.29 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

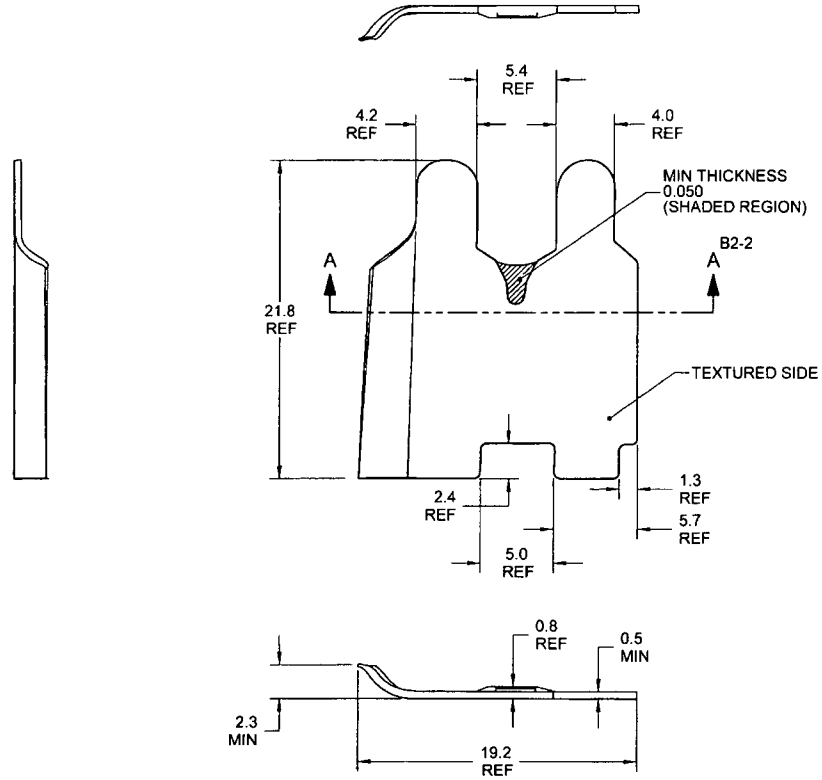
A

D

C

B

A



#50911

SECTION A-A
SCALE 2X

D3874-1 FLOOR PROTECTOR

RELEASED
09/05/05

- NOTES:
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.5 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE EXCEPT AS SHOWN

| | | | |
|------------|----------|--|--------------|
| DESIGN | PEH | DART AEROSPACE LTD | |
| DRAWN | PEH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3874 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR | NTS |
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 50911 |
| Description: FLOOR PROTECTOR | | Part Number: | D3874-2 |
| Inspection Dwg: D3874 Rev: A | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____" | ✓ | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
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|-----------------|----------------|
| Measured by: BB | Date: 09/08/05 |
|-----------------|----------------|

TRIMMING SECTION

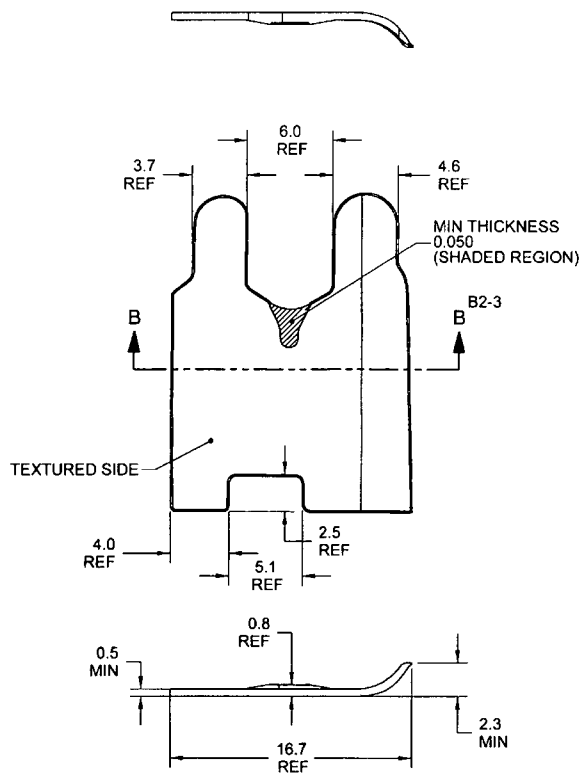
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|------------------|--------|----------------------|----------|
| .050 | Min | .056 | ✓ | | | |
| .055 | Min | .099 | ✓ | | | |
| 0.5 .5 | Min | .537 | 537 ✓ | | | |
| 21.9 | REF | 22. | ✓ | | | |
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|-----------------|----------------|
| Measured by: BB | Date: 09/08/05 |
|-----------------|----------------|

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|---------------|----------------|
| Audited by: S | Date: 09/08/05 |
|---------------|----------------|

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|---------------------|-------|
| Prototype Approval: | Date: |
|---------------------|-------|

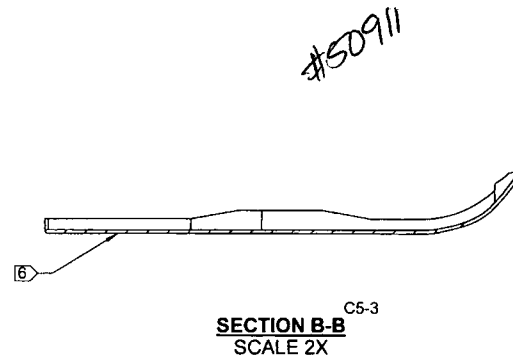
| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |



D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN



RELEASED
9/15/05

| | | | |
|------------|----------|--|--------------|
| DESIGN | PT | DART AEROSPACE LTD | |
| DRAWN | PT | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3874 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | FLOOR PROTECTOR | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries